

Date: Tuesday, 3/11/2008 7:53:29 AM
 Use: Kim Johnston

Process Sheet

12

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-UTILITY BASKET RH
Job Number : 37724	
Estimate Number : 13190	
P.O. Number :	Part Number : D205541046
This Issue : 3/11/2008 S.O. No. :	Drawing Number : IIN D205-541 REV G
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : G
Previous Run : 37516	Material :
Written By :	Due Date : 3/17/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JA 08 03 11</u>	
Comment : Est Rev A new issue 08-02-15 verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD205-541-046	CHG001
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2.0	D3712042	LOW PROFL BASKET BASE ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit	Total : 1.0000 Each(s)
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LOW PROFL BASKET BASE ASSEMBLY	B 37814	mf
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3.0	D3713042	LID ASSEMBLY
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HAI

Comment: Qty.: 1.0000 Each(s)/Unit	Total : 1.0000 Each(s)
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LID ASSEMBLY	B 37197	mf	08-03-17
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4.0	D2258300	Placard
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HAI

Comment: Qty.: 1.0000 Each(s)/Unit	Total : 1.0000 Each(s)
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Placard	B 28072	mf
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Batch: B 28072

5.0	D2332041	Lid Prop Assembly 6.69"
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Comment: Qty.: 1.0000 Each(s)/Unit	Total : 1.0000 Each(s)
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Lid Prop Assembly 6.69"	B 36849	mf
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Batch: B 36849

6.0	D2530	Handle Weldment
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HAI

Comment: Qty.: 1.0000 Each(s)/Unit	Total : 1.0000 Each(s)
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Handle Weldment	B 35357	mf	08-03-17
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Batch: B 35357

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:53:29 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37724

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2535

Spring



HA1

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: B 37071

mf

8.0

D2537

Bushing



HA1

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: B 34788

mf

9.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: B 21139

mf

10.0

AN316A

Bolt



HA 1.

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: m 104603

mf

11.0

AN417A

Bolt



(P10)

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: m 104603

m16895

12.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: m104937

mf

HA1

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)


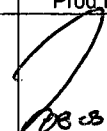

Bolt

Batch: m104547

mf

HA1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-03-17	11-0	AN4-20A bolt required. Perm. Change. 				 08-03-17	 08-03-17	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:53:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37724

Part Number: D205541046

Job Number:



Seq. #:	Machine Or Operation:	Description :
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14.0	AN517A	Bolt
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HA1

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: m107242 x(2), m104625 x(2)

mf.

15.0	AN960JD416	Washer
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Comment: Qty.: 6 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: m106277

mf.

16.0	AN960JD516	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: m106654

mf.

17.0	AN9704	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: m105442

mf.

18.0	MS21042L3	Nut
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HA1

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: m106242

mf.

19.0	MS21042L4	Nut
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HA1

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

Batch: m105938

mf.

20.0	MS21042L5	Nut
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HA1

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: ~~m105938~~ m106277

mf.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37724

Part Number: D205541046

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	MS20600AD4W3	Cherry Rivets
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Cherry Rivets
Batch: m18071

mf

22.0	D37231	BUSHING
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
FWD PLATE

B 37530

mf

23.0	D37571	Blanking Plate
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HAI

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Blanking Plate

B 37473

mf

24.0	AN311A	Bolt
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HAI

(PTO)

Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt

m14820

mf

25.0	AN960JD10	Washer
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HAI

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer

m106167

mf 08-03-17

26.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg.

mf 08-03-17 (PTO)

27.0	QC5	INSPECT WORK TO CURRENT STEP
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08-03-17 (PTO)


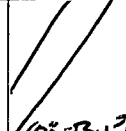


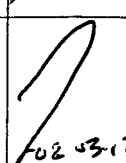
Comment: INSPECT WORK TO CURRENT STEP

28.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-03-17	26	Add AN960JD416L x (2) m <u>106785</u>	mf	08-03-17	2	 080317	 080317	
08-03-17	240	change to A03-11A bolt, to have thread in safety. Perm. change to wro 				 080317	 080317	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37724

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D21991

Struts, 19"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Struts, 19"
Batch: 38065

30.0

D219923

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Strut
Batch: 29382

31.0

D219925

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Strut
Batch: 29131

32.0

D2498

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Mounting Bracket
Batch: 27683

33.0

D2499

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Mounting Bracket
Batch: 27507

34.0

D2515

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing
Batch: 29138

35.0

D30521

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Mounting Lug
Batch: 28522

1283/170

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:53:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37724

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M102170

37.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: M105143

38.0

AN413A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

Batch: M106993

39.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M105653

40.0

AN57A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M106785

41.0

AN513A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104936

42.0

AN960JD416

Washer



Comment: Qty.: 27.0000 Each(s)/Unit Total : 27.0000 Each(s)

Washer

M10495 M106277

683/170

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 01/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:53:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37724

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch: M106604

44.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Batch: M105938

45.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M106277

46.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-044

Location: DART

PPP Rev: 08.03.17

48.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08.03.17
08.03.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. F &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 1
REF. TCCA STC SH96-120, FAA STC SR00696NY & EASA STC EASA.IM.R.S.01242

The Dart D205-541-046 Heli-Utility-Basket is available for installation on the RH side of Bell 205/210/212/214/412 model aircraft as shown in Figure 1 below. The D205-541-048 Heli-Access-Step is not approved for flight at this time.

The D205-541-046 basket should be installed in accordance with the installation procedure for the D205-541-044 basket in Installation Instructions D205-541 Rev. F. The parts list and weight and balance for the D205-541-046 basket is provided in Tables 1 and 2 on sheet 2 of this service instruction.

The D205-541-046 basket should be maintained per Instructions for Continued Airworthiness ICA-D205-541 Rev. 1. The inspection requirements and damage limits for the equivalent components of the D205-541-044 basket are applicable to the D205-541-046 basket.

The aircraft should be operated in accordance with FMS-D205-541, FMS-D214-541 or FMS-D412-541 with the D205-541-046 basket installed.

All parts are common to the D205-541-044 basket except as outlined in Figure 1 below. The D3757-1 blanking plate must remain installed over the openings at the forward and aft ends of the basket as shown in Section A-A of Figure 1 and suitable AN3 hardware must be installed to plug the 4 sets of step mounting holes in the basket ribs as shown in Figure 2.

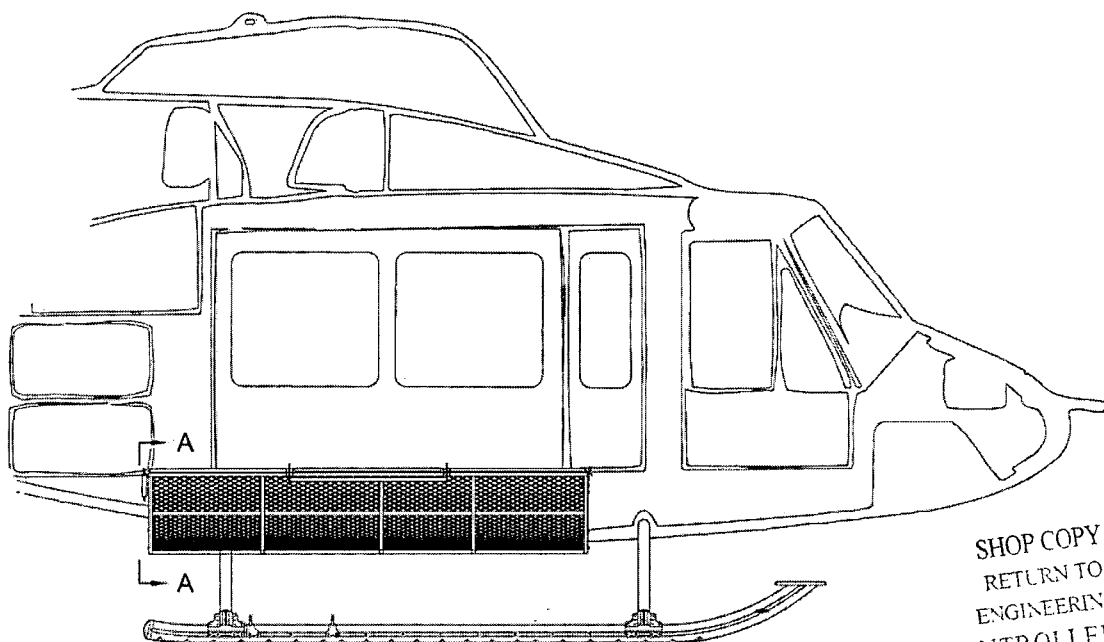


Figure 1. D205-541-046 Heli-Utility-Basket

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37724

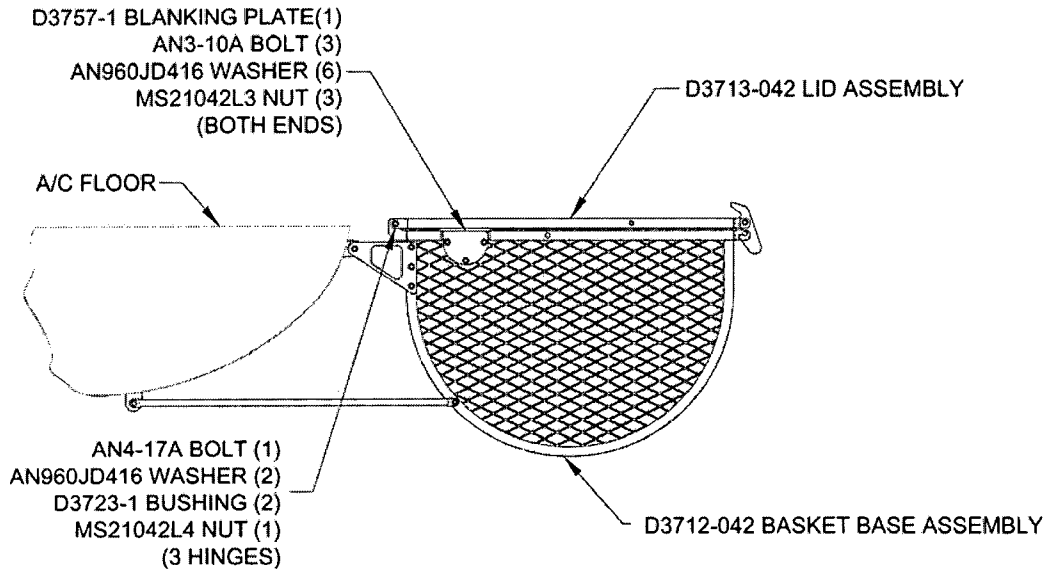
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 08.02.22
CERT. NO.: SH96-120
ISSUE NO.: 3

A	NEW ISSUE	LE	08.02.19
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>LE</i>		
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9404	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HELI-UTILITY-BASKET	NTS
DATE	08.02.19	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



View A-A
 (Refer to Figure 1)

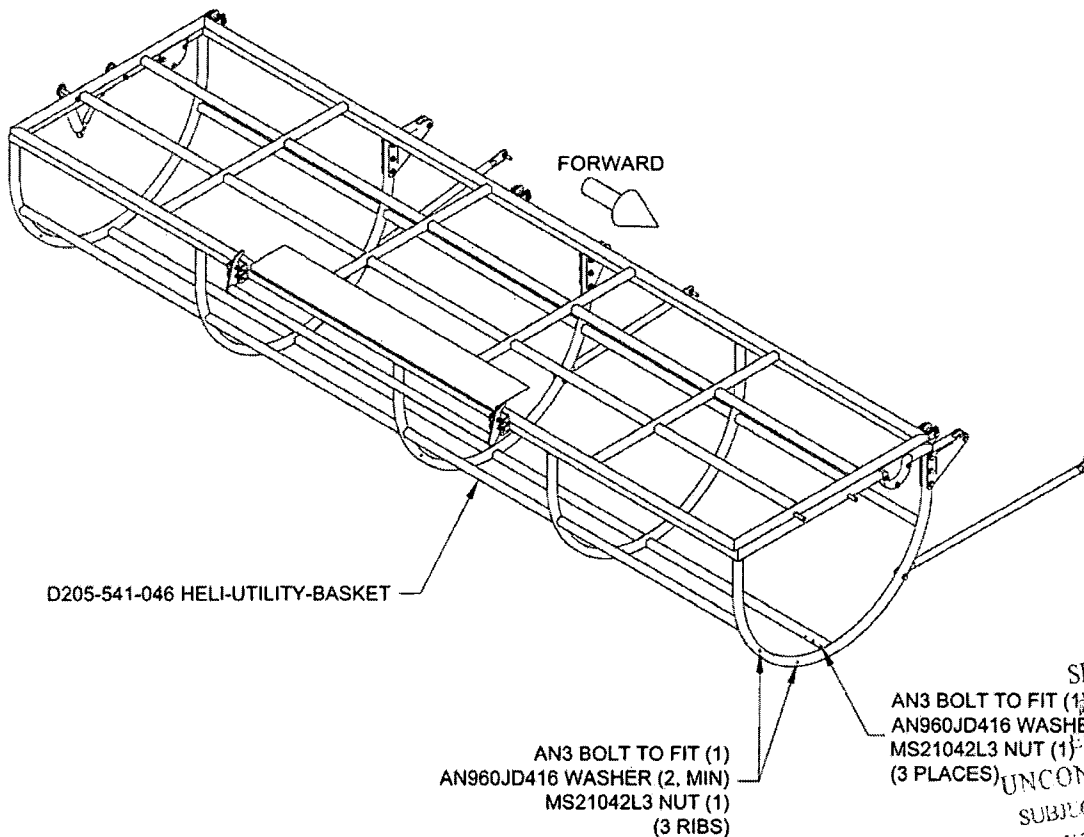


Figure 2. Holes to Plug
 (Basket Mesh Not Shown For Clarity)





SHOP COPY
 RETURN TO
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 37724

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED

BY: D. Shepherd
 D. SHEPHERD (DE # 02)

DATE: 08.02.22
 CERT. NO.: SH96-120
 ISSUE NO.: 3

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9404	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HELI-UTILITY-BASKET	NTS
DATE	08.02.19	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Date: Tuesday, 3/11/2008 7:53:29 AM
User: Kim Johnston

Process Sheet

12

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI-UTILITY BASKET RH
Job Number	: 37724		
Estimate Number	: 13190		
P.O. Number	:	Part Number	: D205541046
This Issue	: 3/11/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN D205-541 REV G
First Issue	: 11	Project Number	:
Previous Run	: 37516	Drawing Revision	: G
		Material	:
Written By	: <u>JA</u>	Due Date	: 3/17/2008
Checked & Approved By	: <u>08 03 11</u>	Qty:	1 Um: Each
Comment	: Est Rev. A new issue 08-02-15 verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD205-541-046 CHG001

08 03 13 JA

2.0	D3712042	LOW PROFILE BASKET BASE ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
LOW PROFILE BASKET BASE ASSEMBLY

3.0	D3713042	LID ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
LID ASSEMBLY

4.0	D2258300	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Placard
Batch: _____

5.0	D2332041	Lid Prop Assembly 6.69"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lid Prop Assembly 6.69"
Batch: _____

REFERENCE ONLY

6.0	D2530	Handle Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle Weldment
Batch: _____